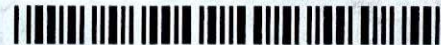




Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D205-634-141
Job Sheet 179615



Part No: D205-634-141

Job Qty: 1 ea

Part Name: Replacement Skidtube with Run-on Landing Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/20/18

Job Tracking No:

Due Date: 7/20/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D205-634 REV.II/ D2580 REV.H IPP RevA 11.09.14 new issue EC verified by:DD IPP REV:B 12.01.23 AS PER ECN11-684 DD VERF:EC IPP REV:C 13.03.21 AS PER ECN13-544 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/20/18	7/20/18	0.00	0.00	Start Up Skidtubes-1		M66
110	Skidtubes	1 pcs	7/20/18	7/20/18	0.00	0.65	Skidtubes-2		m66
120	CNC Bend Skidtubes	1 pcs	7/20/18	7/20/18	0.52	0.65	CNC Bend Skidtube		M66
130	Skidtubes	1 pcs	7/20/18	7/20/18	0.00	0.65	Skidtubes-2		D
140	QC	1 pcs	7/20/18	7/20/18	0.00	0.00	QC5		BE
150	Skidtubes	1 pcs	7/20/18	7/20/18	0.00	0.65	Skidtubes-2		BE
160	QC	1 pcs	7/20/18	7/20/18	0.00	0.00	QC10		13-07-31
170	QC	1 pcs	7/20/18	7/20/18	0.00	0.00	QC5		18-7-31
180	HandFinish	1 pcs	7/20/18	7/20/18	0.00	0.04	HandFinish2		18-07-31
190	Powdercoat	1 pcs	7/20/18	7/20/18	0.00	0.25	Powdercoat1		18-7-31
200	QC	1 pcs	7/20/18	7/20/18	0.00	0.00	QC3		18-7-31
210	HandFinish	1 pcs	7/20/18	7/20/18	0.00	0.83	HandFinish4		BE 18-07-31
220	QC	1 pcs	7/20/18	7/20/18	0.00	0.00	QC5		18-8-1
230	Packaging	1 pcs	7/20/18	7/20/18	0.00	0.00	Packaging3-1		21
235	DC	1 pcs	7/20/18	7/20/18	0.00	0.00	DC		21
240	QC21-FG	1 Ea	7/20/18	7/20/18	0.00	0.00	QC21		21

Part Op 110 - 1- PICK D2580-1 2- SPOT DRILL 2 AFT RUN ON WEARPLATE HOLES USING DT10021, DRILL 3.630" HOLES

Descriptions: USING DT8462 (83.94" FROM AFT OF D2580-1 REF. ONLY)

120 - 1-Bend as per program D2580.C on CNC Bender and Folio FT 16

130 - 1-Deburr ends after cutting and remove bending marks. Prepare tube for welding D2576-3 step remove alodine as required. 2-Locating from most fwd saddle hole, drill most fwd wearplate hole using DT9793 (10.832 REF) as per dwg D2580 sheet 7. 3-Open run-on wearplate holes to finished size 0.508" at locations (5.338/ 5.985/ 10.832/ 3.63 REF) as per dwg D2580 sheet 7. 4-Drill pilot holes for aft cap using DT8215, Open to finished size

150 - 1-Weld step D2576 as per Dwg. D2580 and QSI 004 A/R Aluminum Rod 138851 2-Touch up alodine on run on wearplate holes prior to swaging 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and as per dwg 4-DRILL TOWING HOLE USING DT8091 5-DEBURR

180 - And realodine tube as per QSI 005

190 - START TIME: 1:16pm to 1:46pm 32042

210 - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 18712 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594 3- Install aft cap as per dwg 4- Wing walk as per dwg Batch# M138851

220 - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

230 - Identify and pack for shipping as per PPPD205-634-141 Location : FG084

235 - Photocopy D205-634 bluefile & type labels per PPP D205-634-141 CHG004

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only

Work Order: _____

DISPOSITION

AGAINST DEPARTMENT/PROCESS

Part No. _____

NCR No. _____

Date: _____ Steel

Description Work Order

1670 KAWESBURY COURT
HAWKESBURY, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

DART
AEROSPACE
Container No: S095536



Part: D205-634-141
Job No: 179615
Serial No/Batch: S095536
Revision: H/I
Inspector:
Exp Date:
Instructions: TC STC SH96-88 Issue 2, FAA STC SR00563NY 08/08/11, EASA S1

Completed By
Lead hand / Supervisor
Approval Verification
QC / QA Coordinator
Approval

Jet ☐ Engineering ☐
Cor. ☐ Quality ☐
sing ☐ Other ☐
lier ☐

MRB (QS1042) Approval

Root Cause

Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :	☐		☐		☐		☐
Misidentified	☐	Past Due	☐		☐		☐		☐		☐

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 Ea (1 ea)	90-Start up Operation	5003557
D2576-3	Step (Machining Detail)	1 Ea (1 ea)	150-Skidtubes	5069014
D4202-1	Spacer	24 Ea (24 ea)	150-Skidtubes	5033226
AN3-5A	Bolt	2 Ea (2 ea)	210-HandFinish	5041106-1
AN4-45A	Bolt	8 Ea (8 ea)	210-HandFinish	5094561-1
D2570	Bushing	16 Ea (16 ea)	210-HandFinish	5094814
D2594-1	Plug	8 Ea (8 ea)	210-HandFinish	5054786
D2594-3	O-Ring	8 Ea (8 ea)	210-HandFinish	5084102
D2855	Cap	1 Ea (1 ea)	210-HandFinish	5066018
D4406-041	Fwd Wearplate Assembly	1 Ea (1 ea)	210-HandFinish	5083397
D4406-043	Aft Wearplate Assembly	1 Ea (1 ea)	210-HandFinish	508054
MS21042-4	Nut	8 Ea (8 ea)	210-HandFinish	50876315089336
NAS1149D0332J	Washer	2 Ea (2 ea)	210-HandFinish	5035396-2

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2580-1	1	8	0
150-Skidtubes	D2576-3	1	34	0
	D4202-1	24	236	0
210-HandFinish	AN3-5A	2	194	0
	AN4-45A	8	144	0
	D2570	16	371	0
	D2594-1	8	337	0
	D2594-3	8	595	0
	D2855	1	83	0
	D4406-041	1	2	0
	D4406-043	1	3	0
	MS21042-4	8	41	0
	NAS1149D0332J	2	1,706	0

Part Specifications

Specifications could not be found.

Plex 6/20/18 11:26 AM Dart.lajeunesse.marie

004780

ITEM	QTY -041	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
1	X				D2580-041	SKIDTUBE ASSEMBLY
2		X			D2580-045	SKIDTUBE ASSEMBLY
3			X		D2580-047	SKIDTUBE ASSEMBLY
4				X	D2580-049	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2500-1-190	EXTRUSION
21			16	16	D2570	BUSHING
22	1	1	1	1	D2576-3	STEP
23		4			D2579	SPACER
24	16	16	8	8	D2594-1	PLUG
25	16	16	8	8	D2594-3	O-RING
26	1	1	1	1	D2596	205 WEB
27	1	1	1	1	D2855	AFT CAP
28	1	1			D3584-5	WEARSHOE
29	1	1			D3584-9	WEARSHOE
30	1	1			D3584-11	WEARSHOE
31	1	1			D3584-13	WEARSHOE
32	20	20	24	24	D4202-1	SPACER
33			1		D4408-041	WEARPLATE ASSEMBLY
34			1		D4408-043	WEARPLATE ASSEMBLY
35				1	D5061-1	FWD WEARPLATE
36				1	D5061-3	AFT WEARPLATE
50	50	50			ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
51	50	50			AN3C4A	BOLT
52	2	2	2	2	AN3-5A	BOLT
53			8	8	AN4-45A	BOLT
54	50	50			NAS1149C0332R	WASHER (AN880C10L)
55	2	2	2	2	NAS1149D0332J	WASHER (AN880J10L)
56			8	8	MS21042-4	NUT (OR MS21042L4)

GENERAL NOTES:

- MATERIAL: N/A
- FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT (-041/-047/-049) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
POWDER COAT (-045) GREEN SANDTEX (REF 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: NONE
- WEIGHT: D2580-041 = 33.7 lbs
D2580-045 = 33.7 lbs
D2580-047 = 45.1 lbs
D2580-049 = 32.0 lbs
- WELDING PER DART QSI 004.
- INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- USE DART DRILL TEMPLATE DT8217 & DT8937 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/291.
- INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047/-049)
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 17615 MJS
17-06-20

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2017 JUL 05
ECN17-519

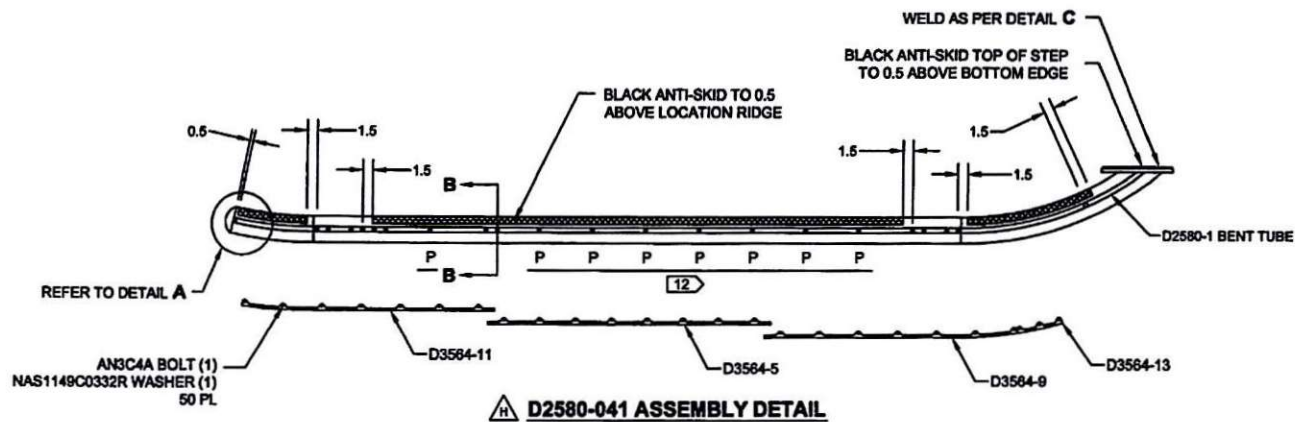
H	SHEET: PL DELETE D3586-1/-5/-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD	17.06.09
G	ADDED -049, -047 WEIGHT UPDATED PER DSI 9598	AJS	14.04.09
F	INCORPORATE DEO D2580-E-1 PER PAR12-218	DC	13.06.20
E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8937 WAS T02577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 8124/ 9183	PH	07.04.05
C	REDRAWN, INCLUDED DEO 9094/ 9097	CP	08.08.26
B	AS MANUFACTURED	DS	06.12.02
A	NEW ISSUE	DS	06.08.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	SAD		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	17.06.09		

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HAWKESBURY, ONTARIO, CANADA

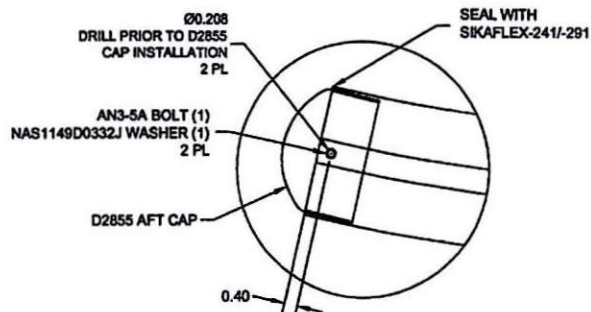
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SHEET 1 OF 9

TITLE 205 SKIDTUBE ASSEMBLY NTS
SCALE

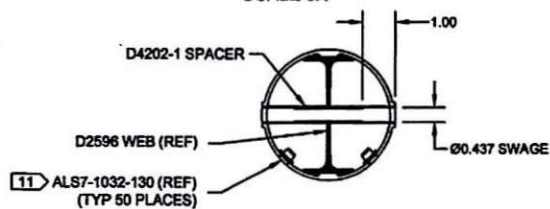
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DETAIL A
SCALE 5X

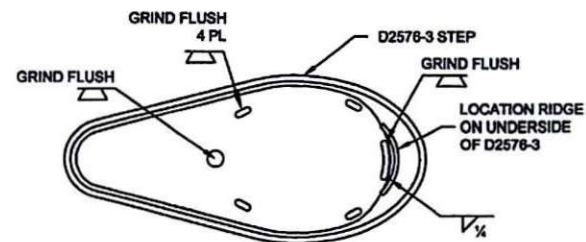


SECTION B-B
SCALE 5X



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

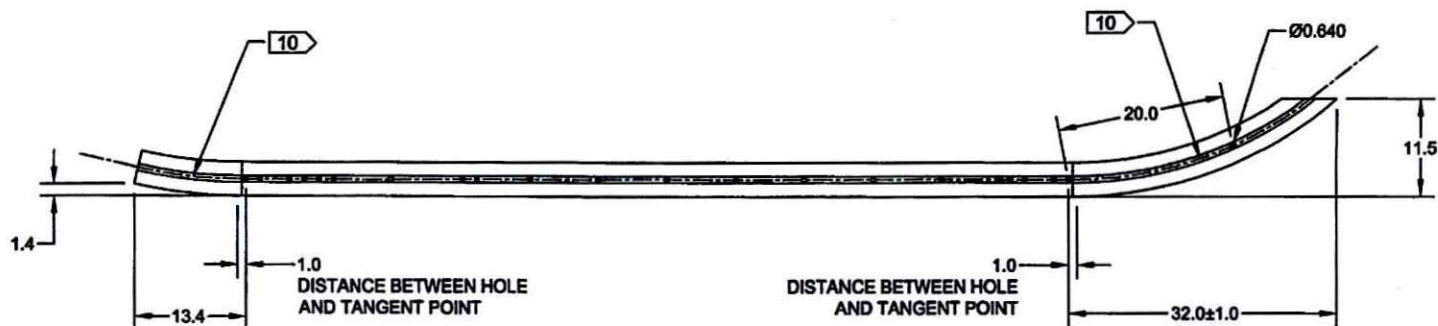
DETAIL C
SCALE 5X



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MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 2 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
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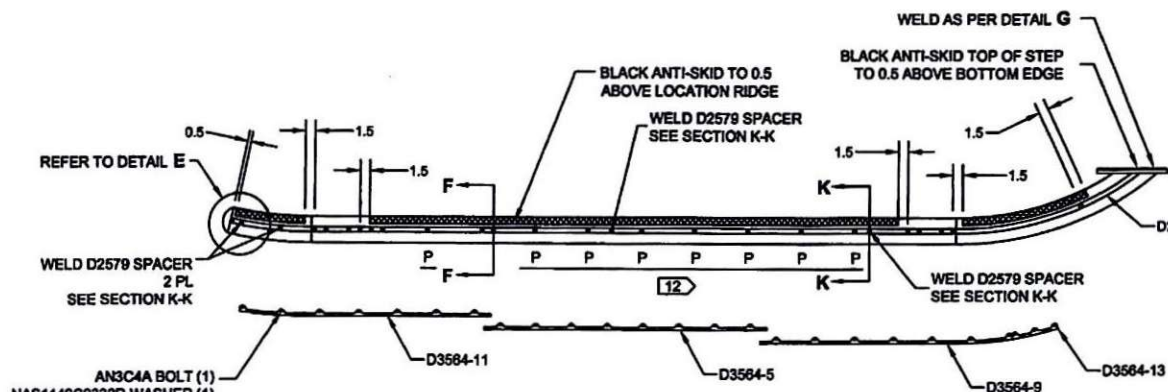


D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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2017 JUL 05 *up*

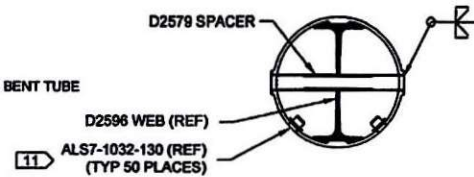
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DRAWN	SAD		
CHECKED	<i>[Signature]</i>	DRAWING NO. D2580	REV. H SHEET 3 OF 9
MFG. APPR.	<i>[Signature]</i>	TITLE 205 SKIDTUBE ASSEMBLY	
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>	SCALE NTS	
DATE	17.06.09		

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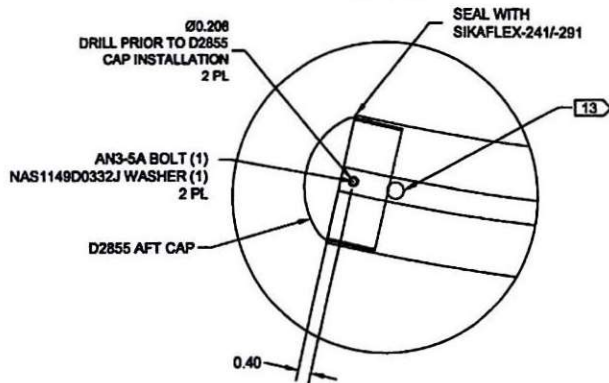
D2580-045 ASSEMBLY DETAIL

**SECTION K-K
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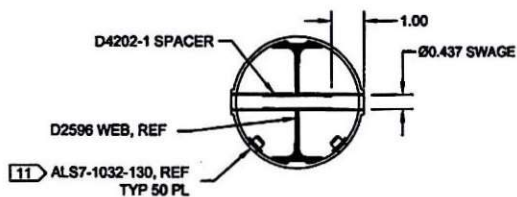


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (4 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. DO NOT C'BORE

**DETAIL E
SCALE 5X**

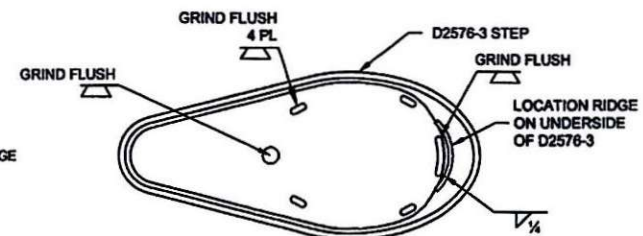


**SECTION F-F
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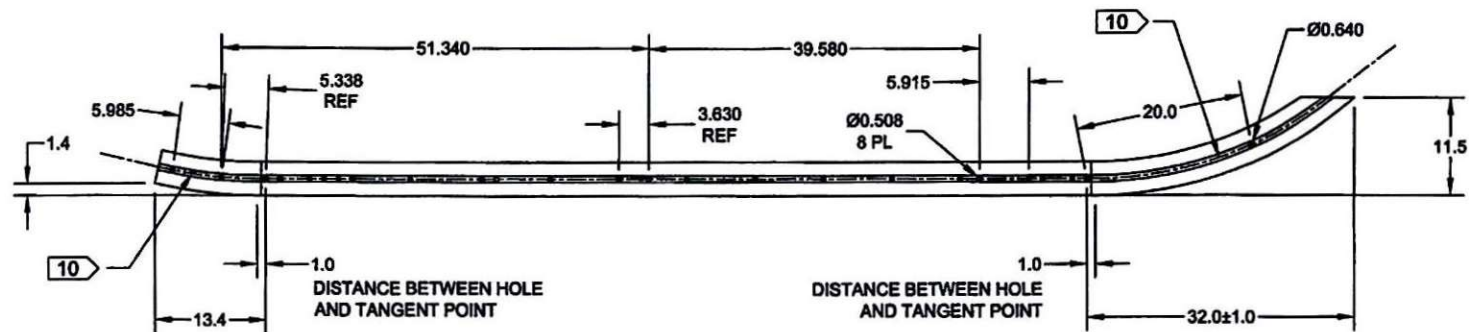
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

**DETAIL G
SCALE 5X**



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DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
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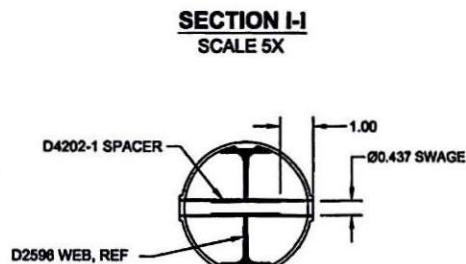
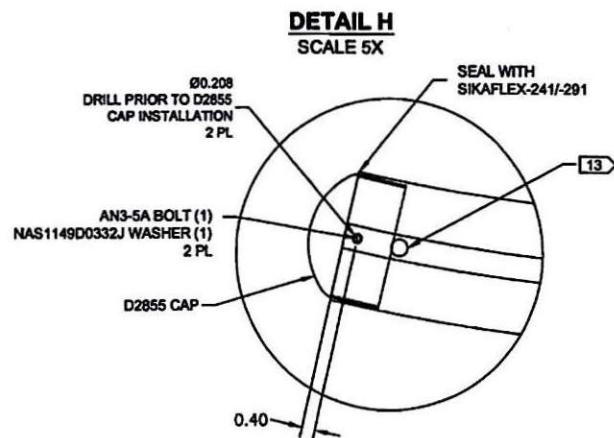
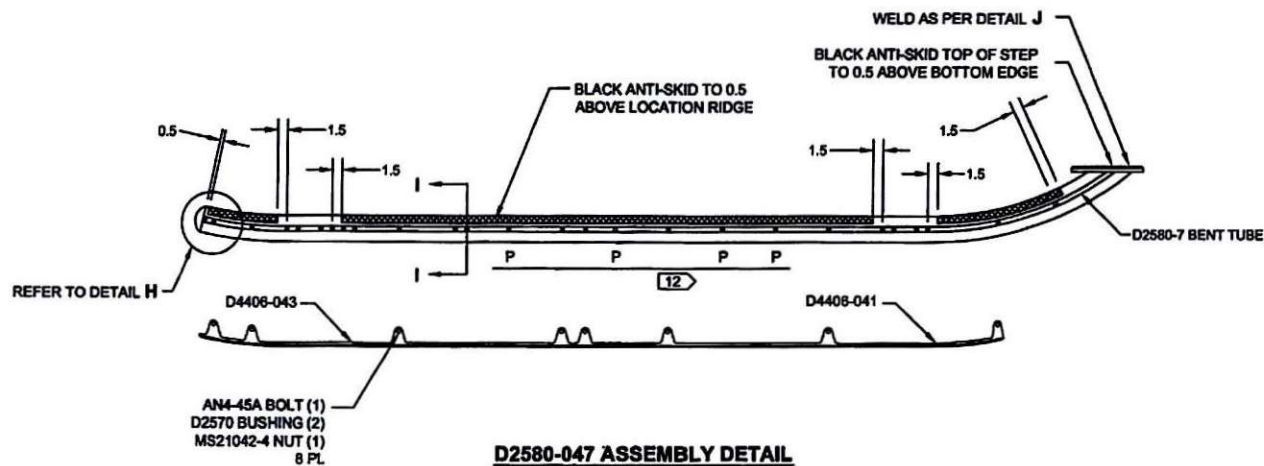


D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

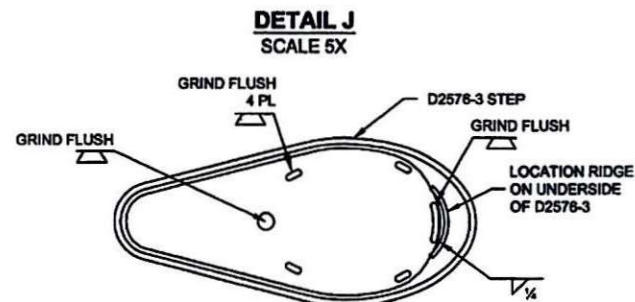
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MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 5 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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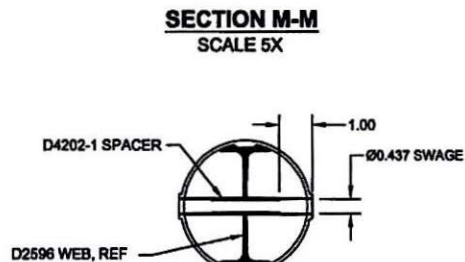
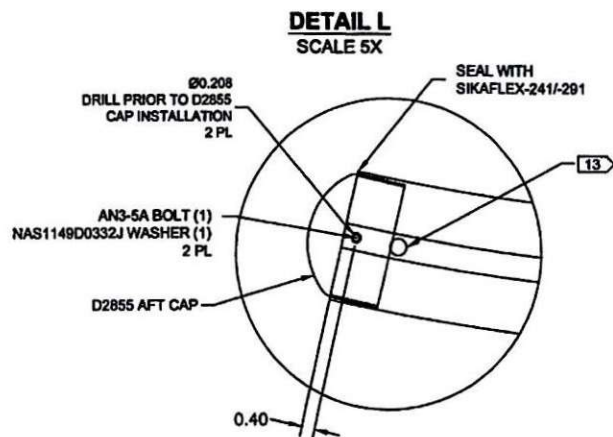
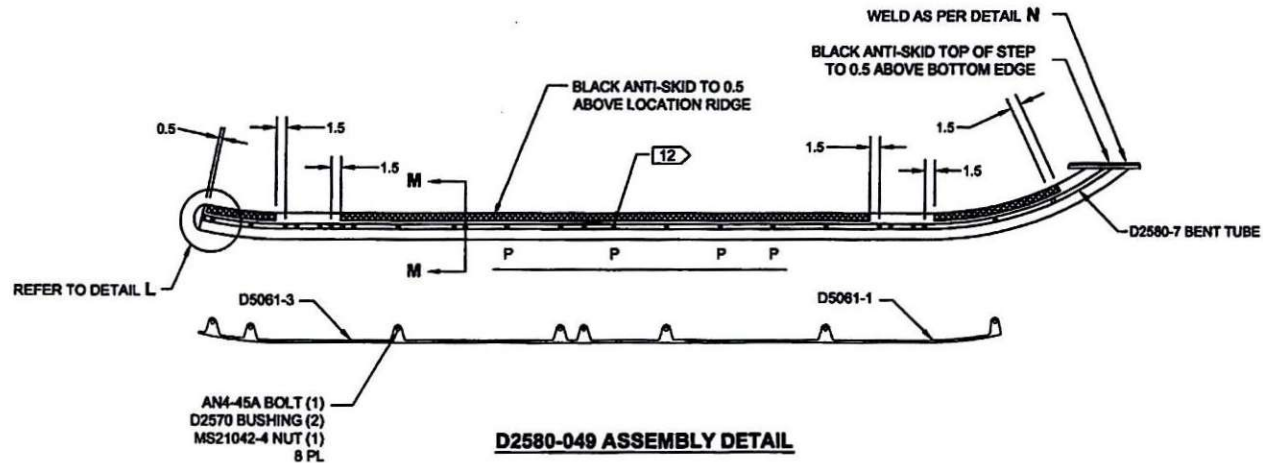
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



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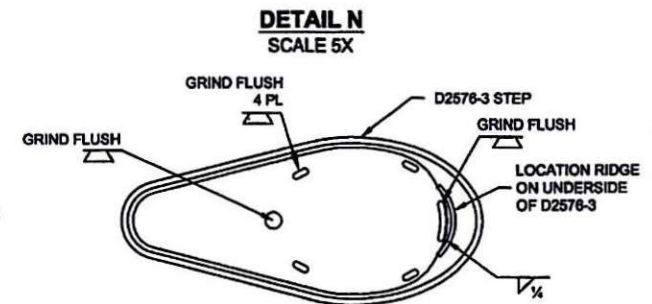
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DRAWN	SAD	HAWKESSBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 8 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
DATE	17.06.09	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

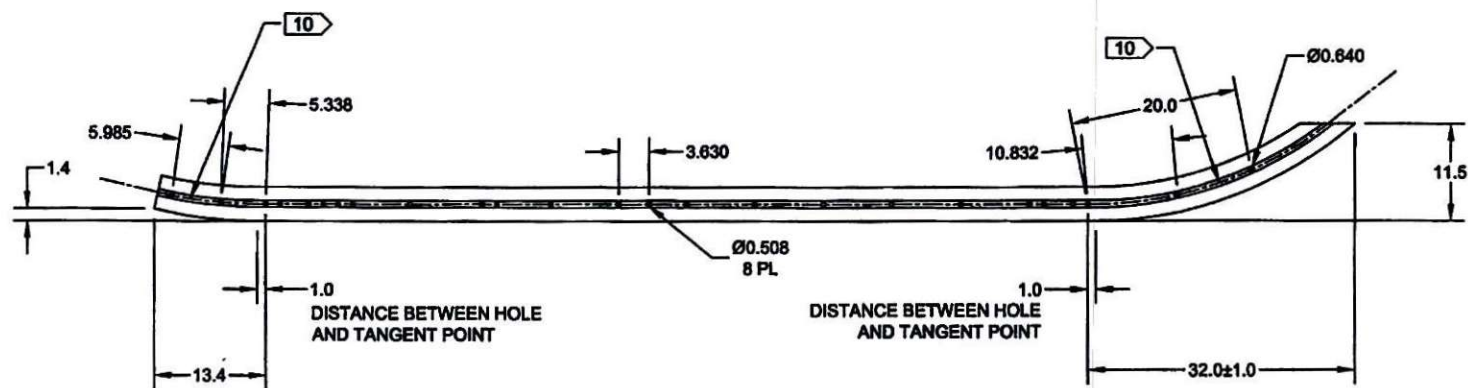
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



RELEASED

2017 JUL 05 *up*

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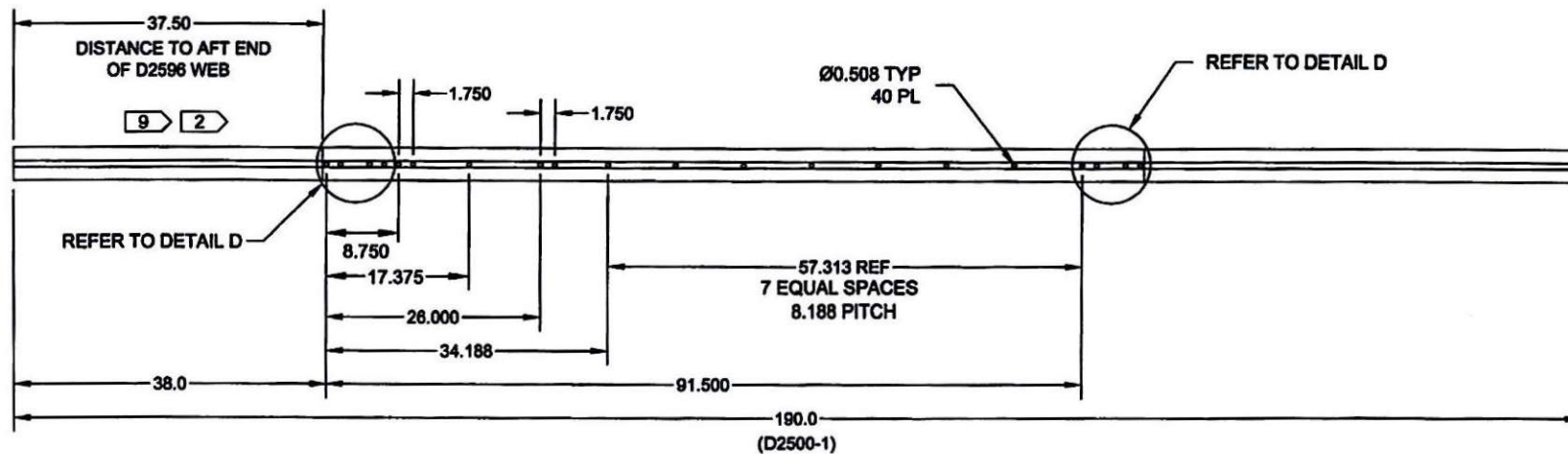


D2580-7 BENT TUBE
(MAKE FROM D2580-101 TUBE)

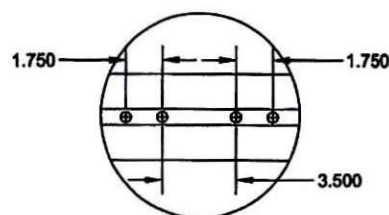
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D2580-101 TUBE



DETAIL D
SCALE 5X

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